

Claims

1. Changeover system (1) for a metal forming mill, in particular for a tube forming mill, the changeover system (1) comprising at least one pair of work modules (10,11), the
5 work modules (10,11) of the at least one pair being adapted to be pivoted (P1,P2) into and out of a line of work stations of the mill, each work module (10,11) having its own drive or drives, wherein within a pair of work modules the two work modules (10,11) are arranged such, that when one work module
10 (10;11) is arranged in the line of work stations the other one (11;10) is arranged off the line.

2. Changeover system according to claim 1, wherein the work modules (10,11) of the pair or pairs of work modules (10,11) are provided with wheels for engaging the floor in
15 order to simplify the pivotal movement of the work modules (10,11) into and out of the line of work stations.

3. Changeover system according to claim 2, further comprising rails arranged on the floor in the area where the pair or pairs of work modules (10,11) are arranged, wherein
20 the wheels of the work modules engage the rails, thus enabling a guided pivotal movement of the work modules (10,11) into and out of the line of work stations.

4. Changeover system according to any one of the preceding claims, wherein the work modules (10,11) comprise
25 rollers (100,110) for forming a tube or an open profile.

5. Changeover system according to any one of the

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preceding claims, comprising at least two pairs of work modules (10,11), the system being adapted to change over the work modules (10,11) of the at least two pairs of work modules (10,11) into and out of the line of work stations at the same time.

6. Metal forming mill comprising a line of work stations and a changeover system (1) according to any one of the preceding claims.

7. Metal forming mill according to claim 6, wherein mill is a tube-forming mill.

8. Process for the changeover from forming of a first metal product to forming of a second metal product in a metal forming mill comprising a line of work stations and a changeover system (1) according to any one of claims 1 to 5, the process comprising the steps of

- stopping the forming of the first metal product
- pivoting that work module (10;11) of a pair of work modules (10,11) which is arranged in the line of work stations out of the line of work stations
- pivoting the other work module (11;10) of the same pair of work modules (10,11) which is arranged out of the line of work stations into the line of work stations
- starting the forming of the second metal product.